



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4149-041
Job Sheet 183432



Part No: D4149-041

Job Qty: 4 ea

Part Name: Aft Crosstube Lug Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP
Rev:C 11.03.03 as per revC DD verf:JLM

Ship Via:

6459

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Small Fab-3	68 9-89	NOV 14 2018
100	Small Fab	4 pcs	10/12/18	10/12/18	0.00	1.00	Small Fab-6		
110	QC	4 pcs	10/12/18	10/12/18	0.00	0.00	QC5		NOV 16 2018 68
120	Packaging	4 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2	57639 6 9-89	NOV 19 2018 9-89
130	QC21-SA	4 Ea	10/12/18	10/12/18	0.00	0.00	QC21		NOV 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	8 Ea (2 ea)	90-Start up Operation	5009999
AN4C13A	Bolt	12 Ea (3 ea)	90-Start up Operation	5092534
D3910-1	Crosstube Lug	4 Ea (1 ea)	90-Start up Operation	512790
D4091-1	Mounting Lug	4 Ea (1 ea)	90-Start up Operation	5117688
D4149-1	Crosstube Lug Plate, Aft	8 Ea (2 ea)	90-Start up Operation	5126638
D4149-3	Spacer	4 Ea (1 ea)	90-Start up Operation	5112785
D4149-5	Eyebolt Stud	4 Ea (1 ea)	90-Start up Operation	5119814
MS20615-4M18	Rivet	12 Ea (3 ea)	90-Start up Operation	5189967
MS21043-3	Nut	8 Ea (2 ea)	90-Start up Operation	5107966
MS21043-4	Nut	12 Ea (3 ea)	90-Start up Operation	5092684
NAS1149C0332R	Washer	16 Ea (4 ea)	90-Start up Operation	5104354
NAS1149C0432R	Washer	24 Ea (6 ea)	90-Start up Operation	5103990

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	8	234	0
	AN4C13A	12	195	0
	D3910-1	4	50	0
	D4091-1	4	40	0
	D4149-1	8	29	0
	D4149-3	4	11	0
	D4149-5	4	5	0
	MS20615-4M18	12	518	0
	MS21043-3	8	1,507	0
	MS21043-4	12	1,101	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐					
NCR _____				Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐					
Date : _____				Finishing ☐	Rec/Store/Packaging ☐	Other ☐					
				Composite ☐	Supplier ☐						
		MRB (QSI042) Approval									
		Disposition									
		Completed By									
		Lead hand / Supervisor Approval Verification									
		QC / QA Coordinator Approval									
Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K8A 1K7 CANADA S1S 6S2-5200 Tel: 519 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S127593 Part: D4149 -- 041 Job No: 183432 Serial No/Batch: S127593 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/14/19											
Environment Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Operator Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Defects Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Category Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Other Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Other Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

NAS1149C0332R
NAS1149C0432R

16
24

5,389
2,733

0
0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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